

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016279**Date Inspected:** 06-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia, Guo Yan Fei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY # 09, OBG DECK PALTE (NWIT # 06342)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

DP3167-001-361, 364, 353, 356

DP3161-001-359, 362, 351, 354

DP3163-001-290, 293, 282, 285

DP3162-001-383, 372, 375, 364, 367

DP3159-001-322, 325, 314, 317, 306, 309

BAY # 03, OBG FLOOR BEAM (NWIT # 06342)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this

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date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

FB3138-001-006, 073, 071, 070, 069, 154, 102, 109

BAY # 08, OBG BIKE PATH (NWIT # 06346)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

BK004A1-061-009

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay # 09, OBG DECK PLATE

During random in process inspection this QA inspector observed that ZPMC NDT personnel Mr. Liu Zhang Min was performing Magnetic Particle Testing (MT) on the weld joints of continuity plate of U-rib of OBG deck plate. The members are identified as OBG components and the weld designations reviewed are as follows.

DP3162-001-320~323, 312~315

DP3161-001-367~370

DP3159-001-366~369, 358~361

DP3163-001-290~293

DP3167-001-361~364

BAY 09, Continuity Plate of U-rib

FCAW welding of weld joint 210 located on DP3171-001.

Welder is identified as 201840. ZPMC CWI is identified as Mr. Guo Yan Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 095 located on DP3171-001.

Welder is identified as 059373. ZPMC CWI is identified as Mr. Guo Yan Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 041 located on DP3171-001.

Welder is identified as 062259. ZPMC CWI is identified as Mr. Guo Yan Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

BAY 06, West Jacking Frame

SMAW welding of weld joint 30 located on WJF-0.

Welder is identified as 215083. ZPMC QC is identified as Mr. Xia Yong Zhang.

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The welding variables recorded by QC appeared to comply with WPS-B-T-3312-Tc-P5.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
